

Date: Monday, 06/10/2008 10:45:00 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BACK PANEL
Job Number	: 42445		
Estimate Number	: 11093		
P.O. Number	:	Part Number	: D30231
This Issue	: 06/10/2008 S.O. No. :	Drawing Number	: D3023 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 37877	Material	:
Written By	:	Due Date	: 30/10/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>Julie Lecocq</u>		
Comment	: Est. C 02.01.23 Revised NG Est Rev:D 08-04-16 now water jet DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S032	2024-T3 .032 sheet
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Comment: Qty.: 3.0216 sf(s)/Unit Total: 3.0216 sf(s)
 2024-T3 .032 sheet
 Material: 2024-T3 sheet (QQ-A-250/4) 0.032"
 Batch: 109240 B8-10-30

2.0	WATER JET	FLOW WATER JET
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(P2) →

Comment: FLOW WATER JET
 1-Cut as per Dwg D3023
 Dwg Rev: A B8-10-30
 Prog Rev: A
 ****graind direction along 28.100" ****
 2-Deburr if necessary B8-10-30

①

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 08/10/30 (20)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Bend as per Dwg D3023

S 08/11/03

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3023-1 PAR #: N/A Fault Category: Prod - Sm Asb NCR: (Yes) No DQA: A Date: 08-11-11
 Resolution: Acceptable Disposition: Use-as-is QA: N/C Closed: AD Date: 08/11/11

NCR: <u>42445</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/10/30</u>	<u>#2</u>	<u>one part has the four holes at 0.191" at 0.198"</u> <u>R.C. wrong Set offset</u>	<u>CP</u> <u>08.10.30</u> <u>PC</u> <u>QSI 042</u>	<u>Acceptable</u>	<u>AB</u> <u>8-10-30</u>	<u>S</u> <u>08/10/30</u>	<u>CP</u> <u>08.10.30</u> <u>PC</u> <u>QSI 042</u>	<u>S</u> <u>08/10/30</u>

NOTE: Date & initial all entries

Date: Monday, 06/10/2008 10:45:00 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACK PANEL

Job Number: 42445

Part Number: D30231

Job Number:



Seq. #: Machine Or Operation: Description:

2-form edge of back pan as per dwg D3023 using D3017-041 back frame

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:30
320°F
8:00

M-L

08/11/05

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-05

QD

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 41957

JL

08/11/05

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/06

Job Completion



MF 08-11-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

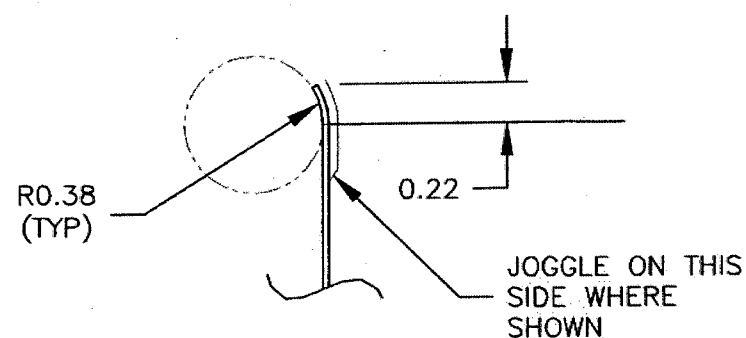
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

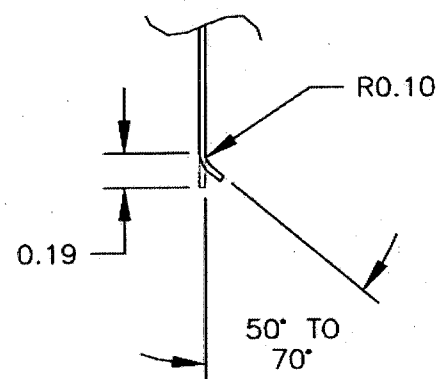
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SECTION A-A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)

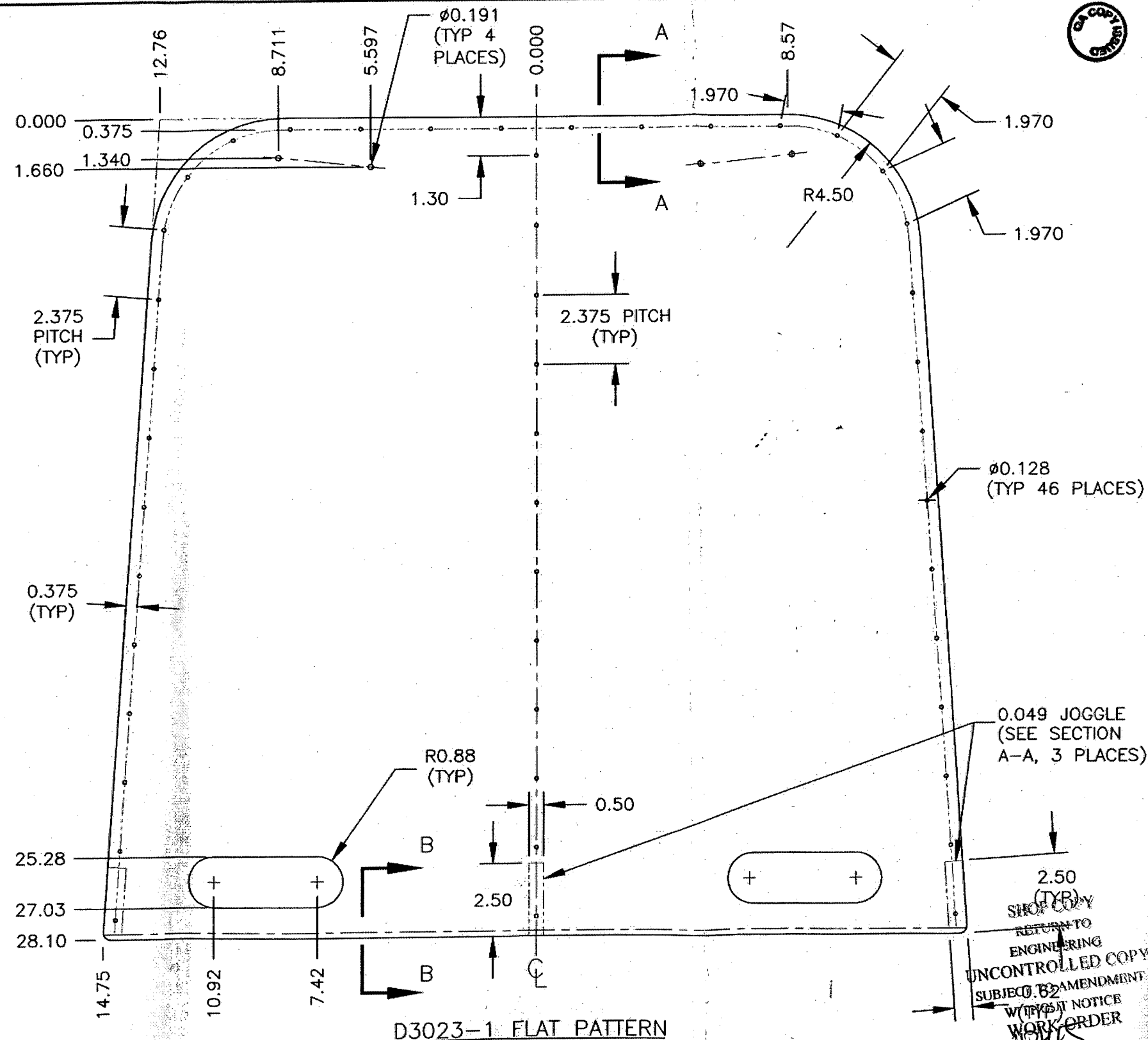


SECTION B-B
SCALE 1:1
(BOTTOM EDGE ONLY)



RELEASED
9.06.07

D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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DART AEROSPACE LTD.

A	01.05.18	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3023
DATE	01.05.18	TITLE BACK PANEL
		REV. A SHEET 1 OF 1 SCALE 1:4

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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42115

